

NASA TECHNICAL
MEMORANDUM



NASA TM X-3192

COST AND SIZE ESTIMATES
FOR AN ELECTROCHEMICAL
BULK ENERGY STORAGE CONCEPT

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NATIONAL AERONAUTICS AND SPACE ADMINISTRATION • WASHINGTON, D. C. • FEBRUARY 1975

1. Report No. NASA TM X-3192	2. Government Accession No.	3. Recipient's Catalog No.	
4. Title and Subtitle COST AND SIZE ESTIMATES FOR AN ELECTROCHEMICAL BULK ENERGY STORAGE CONCEPT		5. Report Date February 1975	
7. Author(s) Marvin Warshay and Lyle O. Wright		6. Performing Organization Code	
9. Performing Organization Name and Address Lewis Research Center National Aeronautics and Space Administration Cleveland, Ohio 44135		8. Performing Organization Report No. E-8138	
12. Sponsoring Agency Name and Address National Aeronautics and Space Administration Washington, D. C. 20546		10. Work Unit No. 506-23	
15. Supplementary Notes		11. Contract or Grant No.	
		13. Type of Report and Period Covered Technical Memorandum	
		14. Sponsoring Agency Code	
16. Abstract Preliminary capital cost and size estimates were made for a titanium trichloride titanium tetrachloride ferric chloride ferrous chloride ($TiCl_3 TiCl_4 FeCl_3 FeCl_2$) redox-flow-cell electric power system. On the basis of these preliminary estimates plus other important considerations, this electrochemical system emerges as having great promise as a bulk energy storage system for power load leveling. The size of this system would be less than 2 percent of that of a comparable pumped hydroelectric plant. The estimated capital cost of a 10 MW, 60- and 85-MWh redox-flow system (\$189 to \$327 per kW) compares well with that of competing systems (\$85 to \$200 per kW). Transmission savings, which could be considerable (\$60 to \$200 per kW), would make the redox system even more attractive.			
17. Key Words (Suggested by Author(s)) Energy storage Redox system Power peaking		18. Distribution Statement Unclassified - unlimited STAR category 44 (rev.)	
19. Security Classif. (of this report) Unclassified	20. Security Classif. (of this page) Unclassified	21. No. of Pages 12	22. Price* \$3.25

* For sale by the National Technical Information Service, Springfield, Virginia 22151

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SUMMARY

Preliminary capital cost and size estimates were made for an electrochemical bulk energy storage concept. The electrochemical system considered was an electrically rechargeable flow cell with a titanium trichloride|titanium tetrachloride||ferric chloride|ferrous chloride ($TiCl_3|TiCl_4||FeCl_3|FeCl_2$) redox couple. The preliminary calculations were made to help determine whether the redox-flow-cell system has an attractive potential as a bulk energy storage system for power load leveling.

With the rise in demand for electric power, the problem facing the electric utility industry of meeting peak power demands has been growing more acute. Because present methods of meeting peak power demands are not entirely adequate, the electric utility industry has been interested in new methods for meeting peak power demands.

On the basis of capital cost estimates, size estimates, and several other important considerations, the redox-flow-cell system emerges as having great promise as a bulk energy storage system for power load leveling. The size of this system would be less than 2 percent of that of a comparable pumped hydroelectric plant. The capital cost of a 10-megawatt, 60- and 85-megawatt-hour redox system would be \$189 to \$327 per kilowatt. This cost compares well with that of competing systems, especially when one considers that for many sites a saving in transmission costs (up to \$200 per kW) could be realized with the redox system. This saving could be achieved because the redox systems could be built in various sizes and located near the load centers. The other important features of the redox system contributing to its power-load-leveling application are its low adverse environmental impact, its high efficiency, its apparent absence of cycle life limitations, and its fast response.

INTRODUCTION

The problem of meeting peak power demands is a very important concern of the

electric utility industry. The problem is growing more acute as the pressure of rapidly rising demand is being felt.

For future power needs, it would be uneconomical to simply "over-design" new base-load plants to meet peak power needs. The capital costs of base-load plants are higher than those of most power peaking equipment in use today (ref. 1). But the methods of power peaking used today are not entirely adequate. Most modern peaking is done with internal combustion equipment, gas turbines and diesel engines, which run on natural gas or petroleum derived fuel. Not only is the efficiency of this equipment lower than that of the base-load plant, but also, and more importantly, the fuel cost can be expected to increase greatly and the fuel availability can be expected to continue to decline. Finally, this type of equipment presents potential air pollution problems.

Another method of power peaking which has been attracting increased interest is the pumped hydroelectric system (ref. 1). Aside from relatively low cost, it is appealing because of its bulk energy storage capacity. There is an increasing desire to keep base-load plants operating at capacity, even during off-peak hours, and to store the energy for periods of peak demand. In some cases it is because the base-load plants use cheaper fuel (e.g., coal) than the power peaking plants (oil or gas). For a nuclear powerplant, maximum economy requires running at full load. Thus, pumped storage offers a means of accomplishing this objective.

However, even the very efficient (of the order of 66 percent) pumped hydroelectric plants have their disadvantages. Siting and environmental limitations restrict this type of energy storage system. Thus, the growing demands will require development of new energy storage systems to meet the particular requirements of a powerplant in the region it serves.

The present report looks into the use of an electrochemical system for bulk energy storage to meet peak power demands. In many ways, electrochemical systems make ideal energy storage and peaking systems. They could be free of siting and environmental problems, provide instant startup in emergencies, operate at high efficiency, permit minimum distance peak load transmission, and require short construction lead times.

The electrochemical system proposed for consideration is an electrically rechargeable flow cell, which is a new concept for bulk energy storage. The heart of the flow cell is a redox couple (a pair of oxidation-reduction reactions in which the ions of the pair remain soluble in their electrolytes in either their oxidized or reduced states). The redox couple considered was titanium trichloride|titanium tetrachloride||ferric chloride|ferrous chloride ($TiCl_3|TiCl_4||FeCl_3|FeCl_2$, or $Ti^{+3}|Ti^{+4}||Fe^{+3}|Fe^{+2}$). Preliminary measurements were made with laboratory cells at the NASA Lewis Research Center (ref. 2). In the present report, size and cost calculations are presented for this redox-flow-cell system. The size calculations include electrochemical characteristics

and physical size of the power unit and characteristics of the principal auxiliaries. In the cost calculations an estimate is made of the possible cost of a 10-megawatt, 85-megawatt-hour plant for power peaking.

The cost estimates for the redox-flow-cell system are quite preliminary. They were made to help determine whether this system has an attractive potential for bulk energy storage in power-peak-leveling applications.

DESCRIPTION OF REDOX-FLOW CELL

The redox-flow cell consists of two compartments containing separate electrolytes and inert carbon electrodes separated by an anion permeable selective ion exchange membrane. On one side an aqueous electrolyte containing a $TiCl_3$ - $TiCl_4$ solution (the anolyte) is circulated from its storage tank into the cell and then back to its tank. On the other side an aqueous electrolyte containing an $FeCl_3$ - $FeCl_2$ solution (the catholyte) is similarly circulated into the cell and back to its tank (fig. 1). On discharge, $FeCl_3$ is reduced to $FeCl_2$, while $TiCl_3$ is oxidized to $TiCl_4$. The ion exchange membrane allows the passage of chlorine ions (Cl^-) from one compartment to the other to preserve electroneutrality. Alternatively, a hydrogen ion (H^+) membrane may also be used. (See fig. 2 for details of electrochemical reactions with either membrane.) The redox-flow cell is electrically rechargeable by simply reversing the direction of flow of current. The redox-flow cell operates at relatively low temperatures, from room temperature to perhaps $80^{\circ} C$.

SIZE OF REDOX-FLOW-CELL POWERPLANT

The basis of the size calculation was a 10-megawatt peak-power-load-leveling plant operating a maximum of 8.5 hours, with an overall efficiency of 70 percent and with both electrolytes at 4-molal concentration. The results of this analysis are shown in table I. The table gives electrochemical characteristics and physical size of the power unit and the characteristics of the principal auxiliaries. Table II contains selected data from a new pumped hydroelectric facility (Northfield, Mass., ref. 3) which are useful for purposes of comparison.

COST ESTIMATES FOR REDOX-FLOW-CELL POWERPLANT

A cost estimate was made for a 10-megawatt, 85-megawatt-hour powerplant. A

current density of 108.0 milliamperes per square centimeter ($100 \text{ A}/\text{ft}^2$), 70-percent overall efficiency, and 4-molal concentrations of electrolytes were assumed.

Pricing

The capital cost estimates were made during the summer of 1973. The costs of electrochemical materials were obtained from suppliers or from trade publications. The unit costs used in the calculations are shown in table III. The cost estimates for process equipment were made chiefly with the assistance of process equipment manufacturers.

A good deal of judgment was involved in making these cost estimates. For example, judgment had to be used in selecting the grade of chemical required and also in securing the estimate of electrochemical materials costs. It was obvious that the estimated costs of the electrochemical materials were not necessarily the lowest. The membrane manufacturers, for instance, predicted that future development and increased production savings could halve the present cost of the membrane. Furthermore, one research worker in membrane technology predicted that the membrane cost might even be reduced to less than one-tenth of its present cost. For reasons such as these two types of electrochemical materials costs were calculated. One was higher or conservative, the other lower or optimistic.

The only pieces of process equipment for which conservative and optimistic costs were calculated were the reactant tanks. If lined carbon-steel tanks would be suitable for this process, they would be approximately half as costly as stainless-steel tanks.

As can be seen in table III, the differences between the conservative and optimistic capital cost totals are considerable. For the base case powerplant (operation at 10 MW for 8.5 hr with 70-percent efficiency) the difference was over a million dollars; the conservative total cost was \$2 867 000, while the optimistic total cost was \$1 846 000.

In addition to this basic cost estimate, conservative and optimistic costs were projected for three other cases. One reflected an assumption of a higher efficiency system, 85 percent instead of the 70 percent for the base case. The other two cost projections were for a shorter period of power-load-leveling operation, 6 hours instead of the 8.5 hours for the base case. One of these cost projections was made for 70-percent efficiency, the other for 85-percent efficiency.

Design Basis

Some pieces of process equipment, such as pumps, heat exchangers, and filters, were more or less within the standard series of types available. Other pieces of

process equipment would have to be custom-fabricated, which could make their cost estimates more uncertain. However, storage tanks are normally custom-fabricated. In the opinion of a leading tank manufacturer, the requirements of the redox-flow-cell system would present no special difficulties.

Estimating the cost of the redox-cell frames did present a unique problem, since redox-cell frames had never been built. However, the redox battery of cells containing graphite sheet electrodes, a diaphragm, and flowing liquids resembles the filter press to a reasonable extent. Consequently, cost estimates were obtained in cooperation with filter press manufacturers.

DISCUSSION

The redox-flow-cell system has several attractive features. Electrochemically the system is a simple one. Unlike batteries, there are no apparent cycle life limitations due to morphology changes in the active materials of the electrodes. Furthermore, repeated deep discharges should be possible without reducing cycle life. The cell should operate at very high overall efficiency. Finally, high efficiency does not require high cell temperatures.

The preliminary cost estimates made in this report show that the redox-flow-cell system is also attractive from a cost standpoint for use in bulk energy storage for power peaking. The estimate for the 10-megawatt plant ranged from \$149 to \$287 per kilowatt, depending upon whether the plant is designed for 6- or 8.5-hour use and whether optimistic or conservative costs are used. In keeping with the paper by Heredy and Parkins (ref. 4), a \$40-per-kilowatt cost was added for ac-dc converters, transformers, and switchgear, so that the cost range was brought up to \$189 to \$327 per kilowatt. In the same paper the capital cost of a pumped hydroelectric system in the 10-megawatt range (2.4- to 10-hr daily operation) is estimated to range from \$85 to \$200 per kilowatt, while a gas turbine system was estimated to cost \$100 to \$200 per kilowatt.

On the basis of these cost estimates plus others reflecting cost of operation, the pumped hydroelectric storage system is potentially the cheapest. (In ref. 4 the delivered energy cost estimate for the pumped hydroelectric system is the lowest.) However, as mentioned in the INTRODUCTION, geographic or environmental considerations or both may preclude its use. No doubt the high end of the capital cost estimate represents the case where geographic conditions are considerably less than optimum. Also, because of environmental considerations, it may not be possible to create a lake holding 17.1 meters (56 ft) of water and covering 1.31×10^6 square meters (323 acres) or to have a site which could provide a 252-meter (825-ft) head, as was done, for example, for the

Northfield hydroelectric project (table II). On the other hand, a redox bulk energy storage plant of the same output as the Northfield plant would occupy less than one-fiftieth of the volume (tables I and II). Furthermore, the fact that the redox-flow-cell system can be built in different sizes can be put to good advantage. For example, significant savings in transmission costs can be achieved by dispersing suitably sized redox energy storage devices throughout the system near the load centers rather than using a very large pumped hydroelectric facility at a single site. One report estimates that this transmission cost saving would range between \$60 and \$200 per kilowatt (ref. 5). This estimate would hold for a typical utility system where the average transmission length would be about 100 miles and the dispersed energy storage facilities would be sited within urban areas.

Naturally, to advance the redox-flow-cell system toward commercialization will require a great deal of effort. In the research and development area there are numerous performance questions and problem areas which will have to be resolved. Some of these are discussed in this report. In the performance category are the as-yet-unattained 648-watt-per-square-meter ($60\text{-W}/\text{ft}^2$) power density and the assumed electrochemical performance at the 4-molal concentrations. Also, there is a significant absence of solubility and reactivity data for the titanium chloride system. The questions of minimization of circulating electrical currents between cells and of the distribution of reactant flow within the cells also require investigation.

Probably the major technological consideration is the membrane. Presently, no membrane is available with very low ionic resistance coupled with very good selectivity. In addition, a suitable membrane must be compatible with the reactants, dimensionally stable for long periods, and inexpensive to produce in large sheets.

CONCLUDING REMARKS

On the basis of capital cost estimates, size estimates, and several other very important considerations the redox-flow-cell system emerges as having great promise as a bulk energy storage system for power load leveling. The size of this system was estimated to be less than 2 percent of the size of a comparable pumped hydroelectric storage plant. The capital cost of a 10-megawatt, 60- and 85-megawatt-hour redox-flow system was estimated to range from \$189 to \$327 per kilowatt.

This capital cost range compares well with that for other power-load-leveling systems (\$85 to \$200 per kW), especially when one considers that no transmission credit (\$60 to \$200 per kW) was included in the redox-system capital cost estimates. The transmission savings could be achieved because of the possibility of building redox systems of various sizes and dispersing them throughout the electrical network near the

load centers. Coupling these attractive estimates of capital costs and size of the redox-flow system with its low environmental impact, its high efficiency at low temperatures, its apparent absence of cycle life limitations, and its fast response produces a power-load-leveling system of strong potential.

Lewis Research Center,
National Aeronautics and Space Administration,
Cleveland, Ohio, December 5, 1974,
506-23.

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TABLE I. - ELECTROCHEMICAL AND SIZE CHARACTERISTICS OF
REDOX-FLOW-CELL POWERPLANT

[10-MW, 85-MWh system; redox flow cell, $\text{TiCl}_3\text{TiCl}_4\text{FeCl}_3\text{FeCl}_2$; operating temperature, 80^0C ; ^a efficiency, 70 percent.]

Electrochemical characteristics	
Current density, mA/cm^2 (A/ft^2)	10.8 to 108.0 (10 to 100)
Voltage per cell, V/cell	0.6
Energy density, Wh/kg reactants + water (Wh/lb reactants + water)	13.25 (6.0)
Power unit size	
Total electrode area, m^2 (ft^2)	
10.8 mA/cm^2 ($10 \text{ A}/\text{ft}^2$)	1.55×10^5 (1.67×10^6)
108.0 mA/cm^2 ($100 \text{ A}/\text{ft}^2$)	1.55×10^4 (1.67×10^5)
Total cell volume, m^3 (ft^3)	
10.8 mA/cm^2 ($10 \text{ A}/\text{ft}^2$)	^b 1.98×10^3 (7×10^4)
108.0 mA/cm^2 ($100 \text{ A}/\text{ft}^2$)	^b 1.98×10^2 (7×10^3)
Total power unit volume, m^3 (ft^3)	
10.8 mA/cm^2 ($10 \text{ A}/\text{ft}^2$)	6.43×10^3 (2.27×10^5)
108.0 mA/cm^2 ($100 \text{ A}/\text{ft}^2$)	4.63×10^3 (1.64×10^5)
Characteristics of principal auxiliaries	
Weight of reactants including water, kg (tons)	6.42×10^6 (7.09×10^3)
Shape of reactant tanks	cylindrical with height equal to diameter
Reactant tank volume, m^3 (ft^3)	
Catholyte tank	^c 2.225×10^3 (7.86×10^4)
Anolyte tank	^d 2.225×10^3 (7.86×10^4)

^a TiCl_4 decomposes in hot water to insoluble titanium dioxide (TiO_2) and hydrochloric acid (HCl). Operation in HCl solution would aid solubility and stability. Solubility and stability data lacking to fix operating temperature accurately.

^bAssumed 1.27-cm (1/2-in.) spacing between cells.

^cBased on 14.2-m (46.4-ft) height and diameter, 4-molal FeCl_3 concentration, and 90-percent discharge.

^dAssumed value (solubility data lacking).

TABLE II. - SELECTED DATA FROM NORTHFIELD
HYDROELECTRIC PUMPED STORAGE FACILITY

[1000-MW, 8500-MWh (max) system; emergency reserve,
2500 MWh.]

Upper (man-made) reservoir	
Volume of water, m ³ (ft ³)	
Total	2.22×10 ⁷ (7.9×10 ⁸)
Usable portion	1.59×10 ⁷ (5.6×10 ⁸)
Surface area, m ² (acres)	1.31×10 ⁶ (323)
Maximum water depth, m (ft)	17.1 (56)
Operating head, m (ft)	
Maximum	252 (825)
Minimum	220 (720)
Powerhouse	
Equipment	
Turbine generators (250-MW)	4
Pumps and motors	4
Cavern	
Dimensions, m (ft) . . .	100×21.3×36.6 (328×70×120)
Volume, m ³ (ft ³)	7.81×10 ⁴ (2.76×10 ⁶)
Rock excavated, kg (tons) . . .	2.27×10 ⁸ (2.5×10 ⁵)

TABLE III. - COST ESTIMATE FOR REDOX-FLOW-CELL
BULK ENERGY STORAGE SYSTEM

[10-MW, 85-MWh system; redox flow cell, $\text{TiCl}_3\text{||TiCl}_4\text{||FeCl}_3\text{||FeCl}_2$; Cl^- membrane; efficiency, 70 percent; 108.0 mA/cm^2 (100 A/ft^2); 4-molal electrolyte concentration.]

(a) Electrochemical materials

Material	Conservative estimate		Optimistic estimate	
	Unit price	Price of item, \$	Unit price	Price of item, \$
^a TiCl_4	\$0.39/kg	550 000	\$0.26/kg	372 000
FeCl_3	\$0.16/kg	194 500	\$0.13/kg	160 000
Cl^- membrane ^b	\$43.00/m ²	812 000	\$0.22/m ²	406 000
Electrodes (porous carbon)	\$0.88/kg	179 500	\$0.59/kg	120 000
		1 736 000		1 058 000

(b) Process equipment

Equipment	Conservative estimate, \$	Optimistic estimate, \$
Reactant tanks ^c (stainless-steel wall at \$3.09/kg; chlorsulfonated polyethylene lining at \$53.80/m ²)	490 000	245 000
Redox-cell frames ^c (polypropylene)	150 000	150 000
Filters ^c (0.410 m ³ /sec (6500 gal/min))	70 000	70 000
Heat exchangers (stainless-steel tubes at \$43.00/m ²)	50 000	50 000
Pumps ^c (96.9 kW (130 brake hp); stainless steel tolerant to solids)	48 000	48 000
Instrumentation and installation (40 percent)	808 000	563 000
	323 200	225 200
	1 131 000	788 200

(c) Totals

Case	Energy, MWh	Efficiency, percent	Conservative estimate			Optimistic estimate ^d		
			Total, \$	Direct current, \$/kW	Alternating current, \$/kW (e)	Total, \$	Direct current, \$/kW	Alternating current, \$/kW (e)
Base	85	70	2 867 000	287	327	1 846 000	185	225
^f Projected case 1	85	85	2 615 000	262	302	1 664 000	166	206
^f Projected case 2	60	70	2 535 000	254	294	1 625 000	163	203
^f Projected case 3	60	85	2 330 000	233	273	1 489 000	149	189

^aRequired TiCl_3 is not available in bulk quantities, while TiCl_4 is. Initially TiCl_3 must be electrochemically converted to TiCl_4 in redox equipment.

^bAvailable membranes not developed for redox-flow cell; opinion of one membrane researcher was that a membrane developed for redox-flow might cost as little as $\$2.69/\text{m}^2$.

^cEstimated with assistance of manufacturer.

^dReactant tanks of carbon syeel would cost approximately half as much as stainless-steel tanks.

^eIncludes \$40/kW cost of transformers, ac-dc converters, and switchgear.

^fScaled down from base case with following 0.6 power rule: ratio of capacities raised to 0.6 power equals ratio of costs (ref. 6).

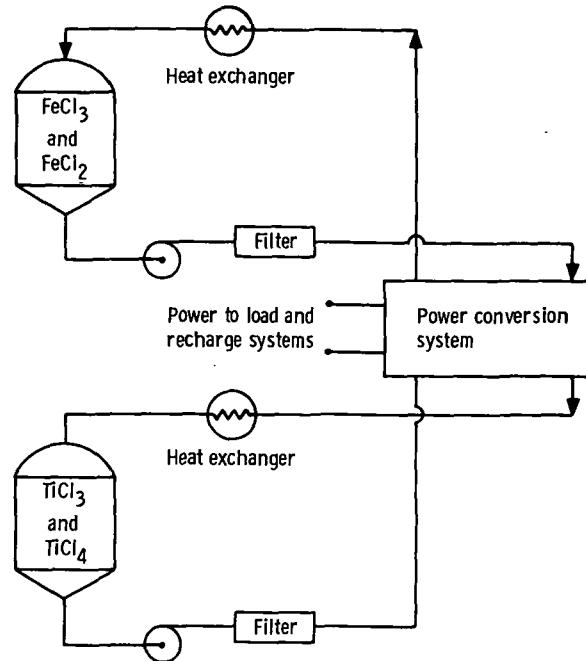


Figure 1. - Electrically rechargeable redox-flow-cell power generation system.

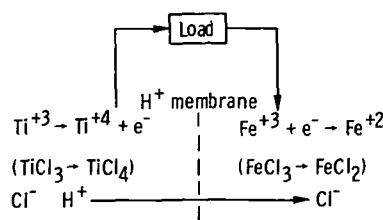
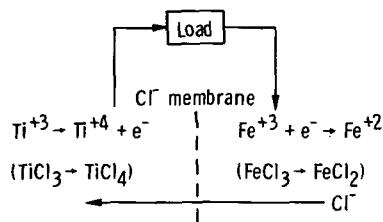
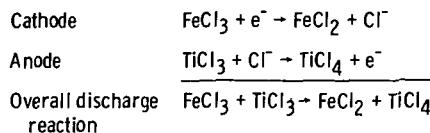


Figure 2. - Electrochemical reactions for redox-flow cell.

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